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D3121-141
Job Sheet 183226



Part No: D3121-141

Job Qty: 10 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/13/18

Job Tracking No:

Due Date: 9/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by: EC
IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	9/28/18	9/28/18	0.00	0.00	Start Up Machining-1		SBL 18/10/4
100	Bandsaw	10 pcs	9/28/18	9/28/18	0.00	1.13	Bandsaw1		SBL 18/10/4
110	CNC Vertical Machining	10 pcs	9/28/18	9/28/18	0.47	19.61	HAAS1-3		SBL 18/10/4
120	QC	10 pcs	9/28/18	9/28/18	0.00	0.00	QC2 Machining-1		SBL 18/10/4
130	QC	10 pcs	9/28/18	9/28/18	0.00	0.00	QC8 Machining-1		SBL 18/10/4
140	Small Fab	10 pcs	9/28/18	9/28/18	0.00	0.28	Small Fab-2		5m/5
150	QC	10 pcs	9/28/18	9/28/18	0.00	0.00	QC5		38
160	Packaging	10 pcs	9/28/18	9/28/18	0.00	0.00	Packaging3-1	5 to 15 88	OCT 04 2018
170	QC21-SA	10 Ea	9/28/18	9/28/18	0.00	0.00	QC21		OCT 05 2018

Part Op 100 - Cut blanks: (1.250" x 2.000") 6.600" long

Descriptions: 110 - 1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111 3-Scribe batch number

140 - Assemble D3121-141 as per Dwg D3121.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.250X2.000	17-4 SS Bar 1.250 x 2.00	5.5000 ft (.55 ea)	90-Start up Operation	5088957
D3121-21	Bolt	10 Ea (1 ea)	140-Small Fab	5049417
D3121-241	Bearing Assembly	10 Ea (1 ea)	140-Small Fab	50115958

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-B1.250X2.000	6	9	0
140-Small Fab	D3121-21	10	71	0
	D3121-241	10	11	0

Part Specifications

Specifications could not be found.



Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____				 Water Jet Prod. Eng. Coord. Tec/Store/Packaging Supplier Engineering Quality Other	
NCR No. _____				Container No: S115966 Part: D3121 - 141 Job No: 183226 Serial No/Batch: S115966 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 10/04/18 Uart Aerospace Ltd. 1270 Aberdeen Street Markham, ON L3R 9K7 CANADA TEL: 1 613 632-8200 Email: sales@dartaero.com www.dartaerospace.com	
Date : _____				MRB (QSI042) Approval	
Des _____				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Root Cause		FAULT CATEGORY					
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong		
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions		
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance		
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect		
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing		
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved		
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing		
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish		
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread		
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence		
Past Expiry Date	Manufacturing Process						
Misidentified	Past Due	OTHER :					

DART AEROSPACE LTD		Work Order: 183226
Description: Bracket		Part Number: D3121-111
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	0.3933	✓		Mic OI	FK-01
0.75	+/-0.030	0.755	✓		Vernier	VHS-01
0.375	+/-0.010	0.3755	✓			
2.14	+/-0.030	2.140	✓			
1.96	+/-0.030	1.965	✓			
0.280	+/-0.010	0.281	✓			
3.330	+/-0.010	3.326	✓		Vernier	VHS-01
3.630	+/-0.010	3.631	✓			
R0.25	+/-0.030	R0.25	✓		RG	
R0.375	+/-0.010	R0.375	✓			
Ø0.201	+/-0.010	0.201	✓		Vernier	VHS-01
0.100	+/-0.010	0.100	✓			
4.580	+/-0.010	4.580		✓		
6.18	+/-0.030	6.185	✓		Vernier	VHS-01
5.89	+/-0.030	5.885	✓		height gage	
0.080	+/-0.010	0.080	✓		Vernier	VHS-01
0.300	+/-0.010	0.300	✓			
30°	+/-0.1°	30°	✓			
R0.25	+/-0.030	R0.250	✓			
0.130	+/-0.010	0.129	✓			
0.664	+/-0.010	0.664	✓			
0.381	+/-0.010	0.386	✓		Vernier	VHS-01
0.201	+/-0.010	0.200	✓			
0.400	+/-0.010	0.399	✓			
0.580	+/-0.010	0.585	✓			
100°	+/-0.1°	100°	✓		Depth gage	VHS-05
0.032	+0.000/-0.010	0.028	✓			

Measured by: DAS 57 9-89 18-10-04	Audited by: DF Date: 18-10-04	Preliminary Approval: Date:
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Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
E	08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD	
F	13.10.22	Tolerance revised for Ø0.201 dimension	KJ	